

Work Order ID 160897***160897***

Page 1

Friday, May 05, 2017 9:44:29 AM

Item ID: PB67-43001-29

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Blade Positioner Weldment

Stop

NS2

Start Date: 5/25/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

DAS
21
9-89

Date:

MAY 05 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-29	C

100

Weld per dwg A/R Aluminum rod Batch: 1129399 0.00***100***

Large Fab

3.57

Large Fab

Memo

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG.
MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO
WELDING****

1- ASSEMBLE AND WELD AS PER DWG

2 @ 175-18

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

② 11-05-19DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.14				②	17-05-19		
Quality Control									
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	1.46				2	φ	17-05-26	33 9-89
Powder Coating	START TIME: 8:50 OVEN TEMPERATURE: 320° FINISH TIME: 9:20								
140	QC3- Inspect Part Finish	0.00							DAS 38 9-89
140									
QC	Memo	0.07				2			
Quality Control									

MAY 29 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: Wnos3

0.00

150

Packaging

Memo

0.07

Packaging

2 MAY 30 2017 DAS
6
9-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.70

Quality Control

DAS
21
9-89

MAY 30 2017

DQA: _____ Date: _____



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Picklist Print

Friday, May 05, 2017 9:44:28 AM

Page 1

Work Order ID: 160897

160897

Parent Item: PB67-43001-29

PR67-43001-29

Parent Item Name: Blade Positioner Weldment

Start Date: 5/25/2017

Required Date: 6/2/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-313

Manufactured

No

100

Each

2.0000

1

7

PR67-43001-313

Plate

Q 17-5-18

Location

Loc Qty

Loc Code

Mezz2

2

152114

2

2

PB67-43001-319

Manufactured

No

100

Each

4.0000

2

14

PR67-43001-319

Gusset

Q 17-5-18

Location

Loc Qty

Loc Code

Mezz2

4

142354

4

4

PB67-43001-337

Manufactured

No

100

Each

3.0000

2

14

PR67-43001-337

Stop Plate

DAS
6
9-89

Location

Loc Qty

Loc Code

Mezz2

3

142355

1

152108

2

1

2

1

160835X1

DQA: _____ Date: _____



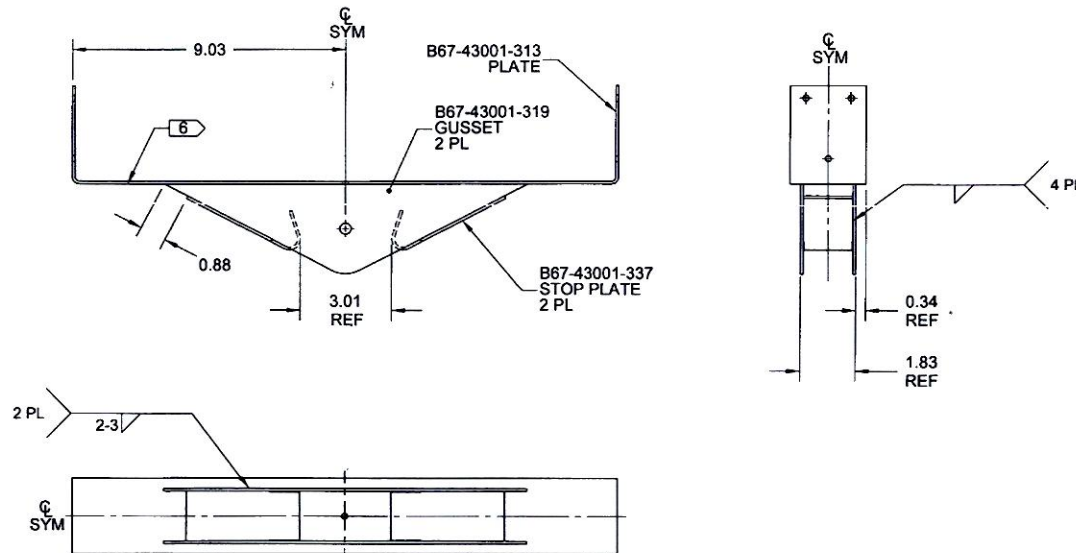
WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -29	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.01 lbs
- 8) WELDING: PER QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160897MJS
H05-05

RELEASED
2009-09-24
MB

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	AS		
CHECKED	AA		
MFG. APPR.	AA		
APPROVED	AA		
DE APPR.	N/A		
DATE	09.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-29** REV. C
SHEET 1 OF 1

TITLE **BLADE POSITIONER WELDMENT** SCALE NTS

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